

Work Order ID 144344

Thursday, August 25, 2016 10:18:05 AM

Repeat
144344

Page 1

Item ID: D2991-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Door

Start Date: 4/14/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/1/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***QC: *[Signature]*

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2991

E

110

0.00

110

Purchasing

Purchasing

Purchasing

Memo

Issue P/O: *32119*

Description: D2991-2 side door

Supplier: Delastek

Ship to delastek: Qty 2 D2992-1

Doubler batch: _____

Ship to Delastek (1) D0589-XXX label

Batch: _____

Certificate of Conformity and process sheet from Delastek

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Packaging

Memo

Ensure certificate of conformity is attached

AUG 26 2016

16.06.22
[Signature]
DAS
6
8-89

Work Order ID 144344

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144344

Page 2

Item ID: D2991-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Side Door
Start Date: 4/14/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/1/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC6- Inspect dimensions to drawing Memo Ensure Material certification comply to Dwg D2991	0.00 0.00				_____	_____	_____	DAS 16 9-89 16/08/26.
<i>* DOOR NEED to be trimmed AS PER instructed *</i>									
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo used on w/o 144573	0.00 0.01				_____	_____	_____	DAS 16 9-89 16/08/26
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10				_____	_____	_____	 AUG 29 2016

DAS
21
9-89

AUG 26 2016

Picklist Print

Page 1

Thursday, August 25, 2016 10:18:05 AM

Work Order ID: 144344

144344

Parent Item: D2991-2

D2991-2

Parent Item Name: Side Door

Start Date: 4/14/2016

Required Date: 6/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC
 IPP Rev:B 08-02-20 ECN 1096 DD verified by:EC IPP Rev:C
 10.10.13 AS PER DWG REV.E DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2991-2P *D2991-2P* Side Door		Purchased		No		110	Each	0.0000	1	1 DAS 6		AUG 25 2016	
D2992-1 *D2992-1* Doubler		Manufactured		No			Each	1.0000		2 9-89		AUG 25 2016	

Location

Loc Qty

Loc Code

ST014

1

144555

1

D2991-1/-2/-3 SIDE DOOR

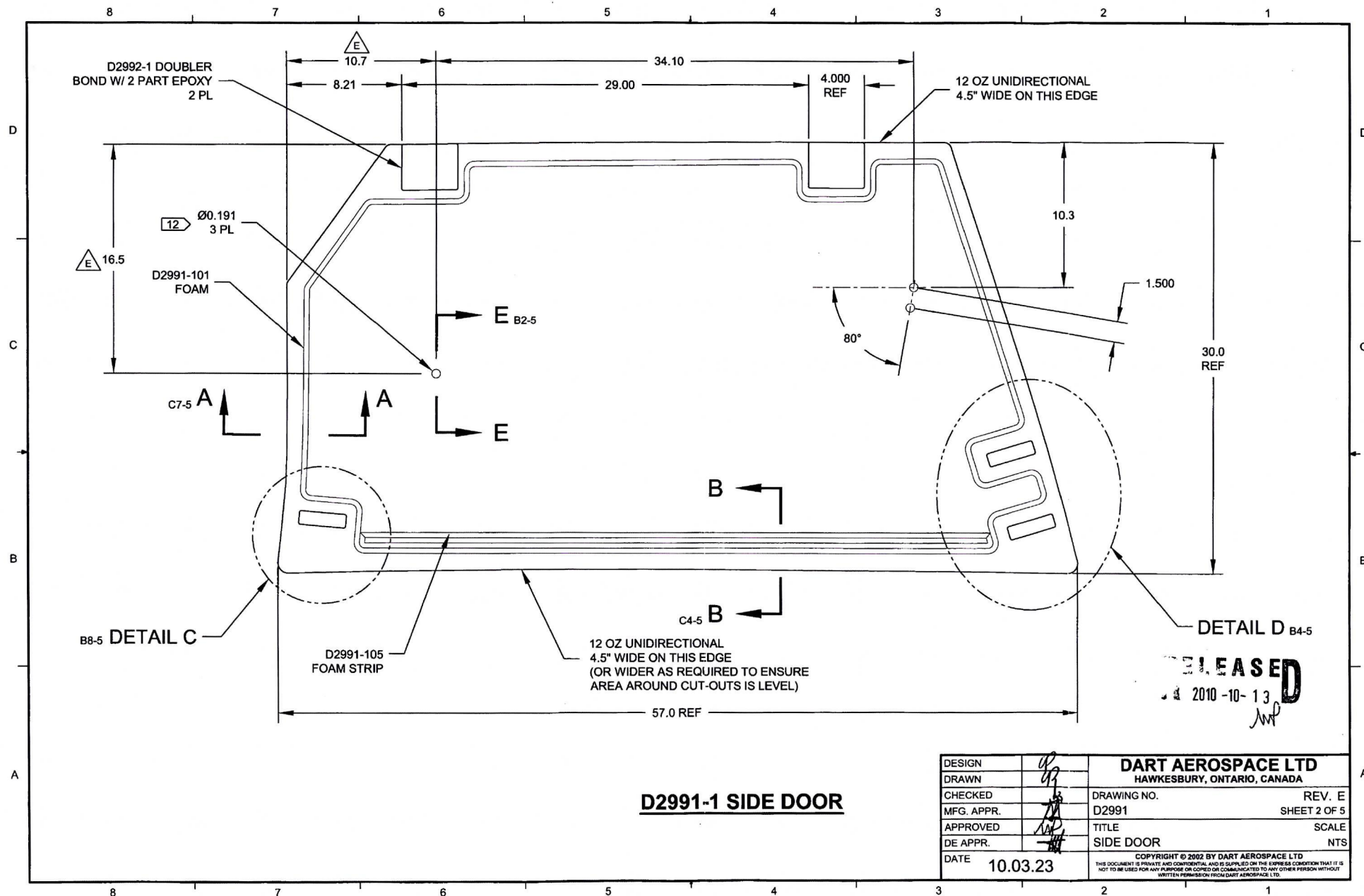
NOTES

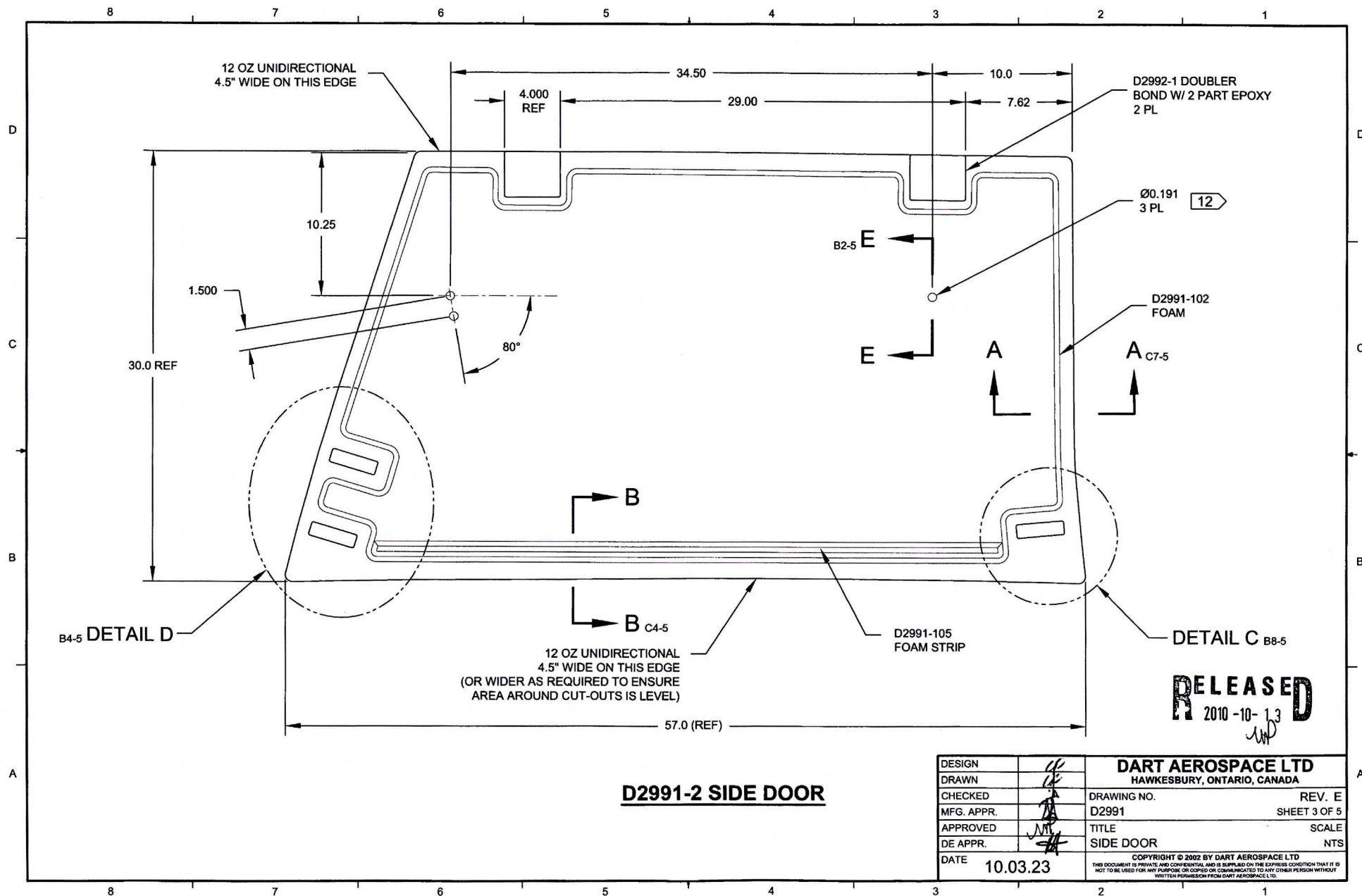
- 1) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 2) FINISH: FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9 lbs TYP
- 8) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 9) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 10) LAYUP PER QSI 006 AND AS FOLLOWS:

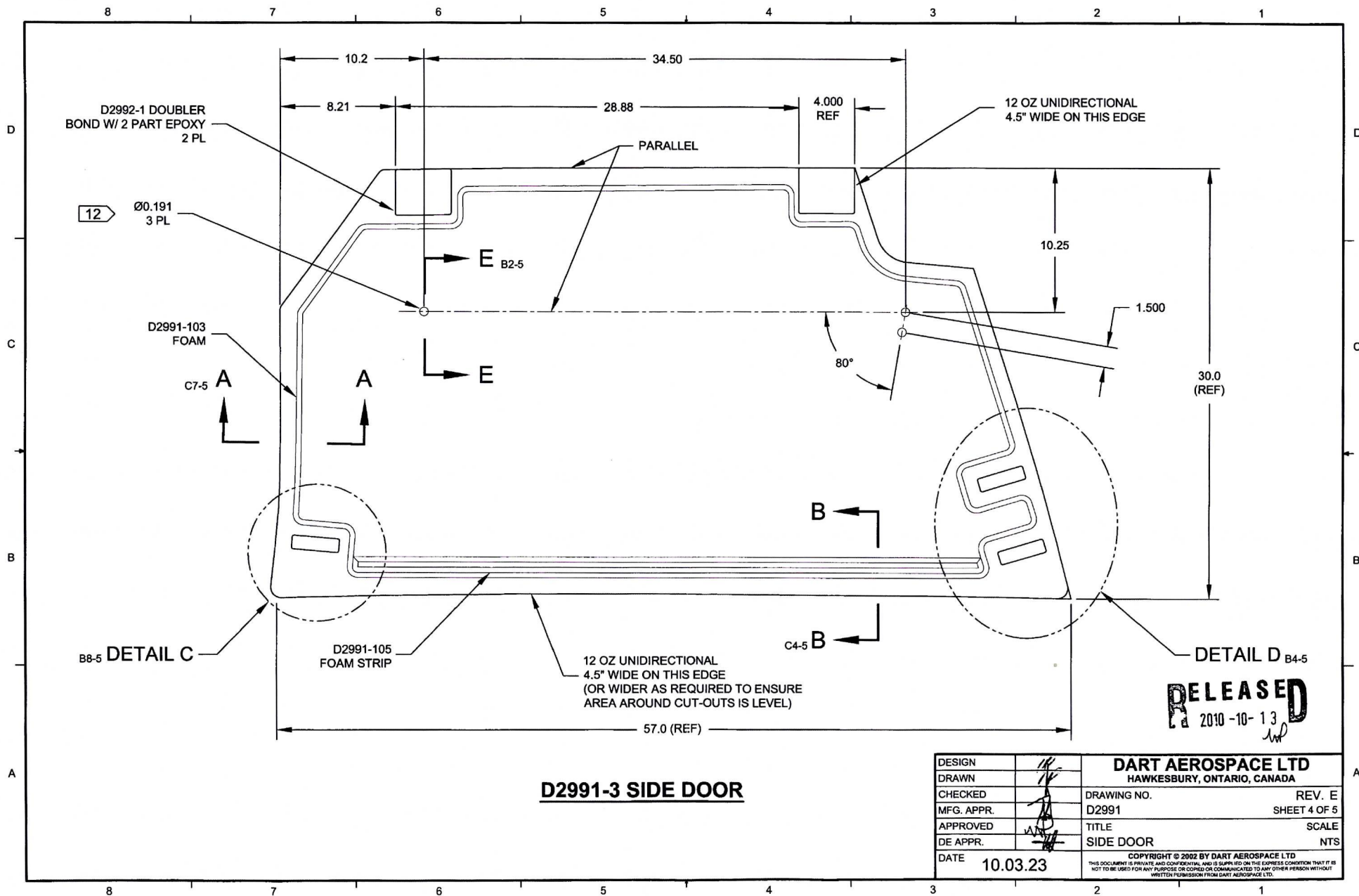
MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 11) BOND FOAM CORE USING POLYBOND B46F
- 12) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.

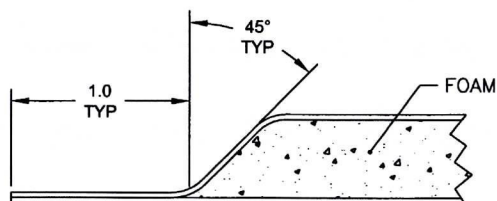
E	REFORMAT, MOVE HOLE: 16.5 WAS 10.25 (ZN C8-2) 10.7 WAS 10.2 (ZN D7-2), PAR 10-007	CP	10.03.23
D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2991	REV. E SHEET 1 OF 5
TITLE SIDE DOOR	SCALE NTS
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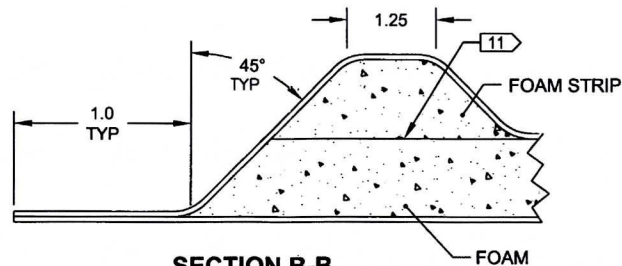




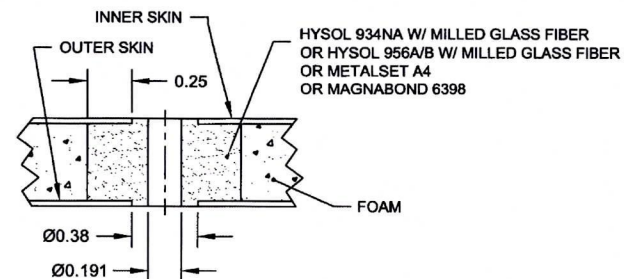




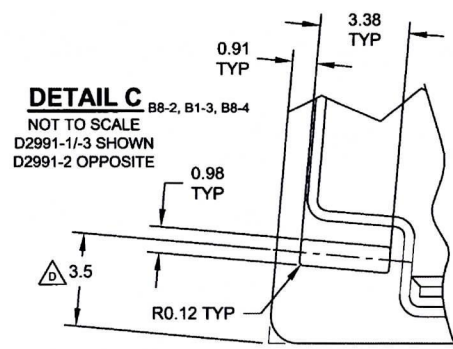
SECTION A-A C7-2, C2-3, C7-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



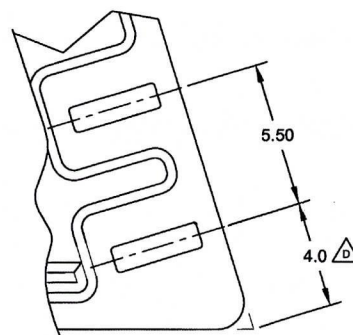
SECTION B-B B4-2, B5-3, B4-4
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION E-E D6-2, D3-3, C6-4
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE



DETAIL C B8-2, B1-3, B8-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D B1-2, B8-3, B1-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

RELEASED
2010-10-13

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2991	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	10.03.23	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO62119

Purchase Order Date 4/21/2016

PO Print Date 8/11/2016

Page Number 1 of 2

Order From : VC-FDC01
FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-357-1344 ext303

Ship To Contact
Ship To Phone

Ship Via Cust arrange p/u
Ship Acct

Buyer Linda Lacelle
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req. Qty/ Unit of Measure	PO Unit Price	Extended Price
1	15002-00 D2991-2 Side Door	Tooling Repairs, Cutting and Drilling Jigs	5/9/2016 Yes 5/9/2016		1.00	\$3,100.00	\$3,100.00
Line Total:							\$3,100.00
2	D2991-2P PER DRWG D2991-2 REV.E B144344	Side Door	6/29/2016 Yes 6/29/2016		1.00 Each	\$1,360.00	\$1,360.00
Line Total:							\$1,360.00
3	D2991-2P PER DRWG D2991-2 REV.E B144489	Side Door	6/29/2016 Yes 6/29/2016		1.00 Each	\$1,360.00	\$1,360.00

Note:

6/24/2016

25 / 8/16
SP

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tel.: 450 357-1344

Shipping Order

18/08/2016

Order : 2518
Reference : PO #32119/2-3

Customer: Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Ship To
DART AEROSPACE LTD
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7
Tel.: 1 613 632-9577

Item No.	Description	Qty	Qty. Delivere	B/O Qty
D2991-2P	Side Door PO item: 32119/2 PER DRWG : D2991 REV. E	1		
D2991-2P	Side Door PO item: 32119/3 PER DRWG : D2991-2 REV. E THIS IS A NO CHARGE MODIFICATION AS PER DART'S REQUEST CANADIAN CURRENCY	1 <i>25/8/16</i> <i>30</i>		

Shipping : _____

Package No : _____

Merchandise Received: _____

Ref. : _____

CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

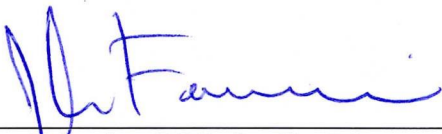
Customer P/O Number: 32119

Revision: A

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number Part</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
3	1	D2991-2P Side Door	D2991 Rev.E	TBD	DAE015-002	2016-05-24

NOTE : This is a no charge modification as per Dart's request. Part has been retrimmed to suite next assembly dimensions.

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: 
Jules Fournier, BDI, Quality Manager

Date: 2016-08-18